

### **Abstract of the Disclosure**

A process for preparing a Ni, Fe and Co base superalloy ingot for hot working and an ingot assembly made by the process are disclosed. The process includes the steps of providing a cast ingot and inserting the ingot into a steel canister that is dimensioned to wholly contain said ingot. The ingot is positioned within the steel canister so as to provide a space between the ingot and the steel canister. After the ingot is positioned in the steel canister, metal powder is filled into the space. The metal powder is selected to readily bond with the surfaces of said ingot and the steel canister. The steel canister is then closed with the ingot and the metal powder inside. Gas and moisture are removed from the interior of the steel canister. The steel canister with the ingot and the metal powder inside is hot isostatically pressed to form an ingot assembly having a cladding formed about the entire longitudinal and end surfaces of the ingot. The ingot assembly that is produced from this process is readily hot worked without significant damage to the ingot from cracking or checking.